

Date: Wednesday, 7/5/2006 2:51:22 PM  
 User: Kim Johnston

## Process Sheet

|                                    |                                        |                           |                            |
|------------------------------------|----------------------------------------|---------------------------|----------------------------|
| <b>Customer</b> :                  | CU-DAR001 Dart Helicopters Services    | <b>Drawing Name</b> :     | BASKET BASE ASSEMBLY (350) |
| <b>Job Number</b> :                | 27817A                                 |                           |                            |
| <b>Estimate Number</b> :           | 10189                                  |                           |                            |
| <b>P.O. Number</b> :               | N/A                                    | <b>Part Number</b> :      | D2221                      |
| <b>This Issue</b> :                | 7/5/2006                               | <b>S.O. No.</b> :         | N/A                        |
| <b>Prsht Rev.</b> :                | NC                                     | <b>Drawing Number</b> :   | D2221/D2235                |
| <b>First Issue</b> :               | N/A                                    | <b>Project Number</b> :   | N/A                        |
| <b>Previous Run</b> :              | 27816A                                 | <b>Drawing Revision</b> : | F/B1                       |
|                                    |                                        | <b>Material</b> :         | N/A                        |
| <b>Written By</b> :                | <b>Due Date</b> :                      |                           | 7/30/2006                  |
| <b>Checked &amp; Approved By</b> : | <b>Qty:</b>                            |                           | 1 Um: Each                 |
| <b>Comment</b> :                   | Est Rev:J 05.09.02 Added D3442-1KJ/JLM |                           |                            |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |        |             |
|-----|--------|-------------|
| 1.0 | D31661 | Basket Hoop |
|-----|--------|-------------|



**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3166-1

RIB

327326

CPL 06.07.10

|     |        |              |
|-----|--------|--------------|
| 2.0 | D22323 | Basket Hinge |
|-----|--------|--------------|



**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3

Hinge bracket

324527

CPL 06.07.10

|     |       |                          |
|-----|-------|--------------------------|
| 3.0 | D2325 | Support Gusset (350 Bask |
|-----|-------|--------------------------|



**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2325

Support Gusset

326741

CPL 06.07.10

|     |        |                |
|-----|--------|----------------|
| 4.0 | D23273 | Spacer Bushing |
|-----|--------|----------------|



**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2327-3

Bushing

327051

CPL 06.07.10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 7/5/2006 2:51:22 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27817A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket

*B27524*

*CPL 06-07-10*

6.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim

*B26739*

*CPL 06-07-10*

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty Part Number Description Batch

36 sf M304EX0.75-16F Expanded Metal

*M101358*

*CPL 06-07-14*

8.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SS tubing

Batch: *M101359* → *336101*

*CPL 06-07-10*

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

*CPL 06-07-18*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/14

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 7/5/2006 2:51:23 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27817A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06-07-19 ①

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/08/04 ①  
DU

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/08/10 ①

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M101621

Expiry date: 02/2007

M.F. 06/08/10

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

①  
06/08/14

Job Completion



CLO 06/08/14

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



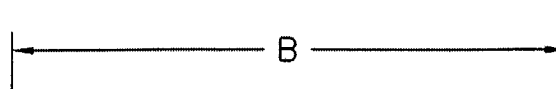
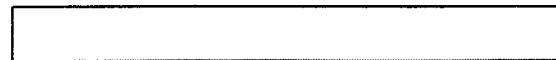
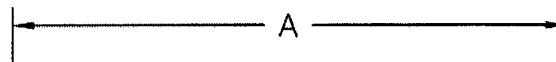
|                               |                                |                                                           |                        |
|-------------------------------|--------------------------------|-----------------------------------------------------------|------------------------|
| DESIGN<br>BW                  | DRAWN BY<br>PH                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2221                                      | REV. F<br>SHEET 1 OF 3 |
| DATE<br>05.06.07              |                                | TITLE<br>BASKET BASE ASSEMBLY (350)                       | SCALE<br>NTS           |
| C                             | 95.11.21                       | SEPARATE BASKET AND LID                                   |                        |
| D                             | 96.06.21                       | CHANGE LATCH                                              |                        |
| E                             | 01.04.19                       | CHANGE HINGE                                              |                        |
| F                             | 05.06.07                       | ADD SHIM UNDER HINGES,<br>ADD HOLES FOR SPLIT LID BASKETS |                        |

RELEASED

05.08.19 *[Signature]*

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

| PART NO | QUANTITY | LENGTH<br>A | LENGTH<br>B | DESCRIPTION    |
|---------|----------|-------------|-------------|----------------|
| D2221-1 | 2        | —           | 96.00       | RIB            |
| D2221-3 | 2        | —           | 25.50       | RIB            |
| D2221-5 | 2        | 18.88       | —           | RIB            |
| D2221-7 | 1        | 55.25       | —           | RIB            |
| D2232-3 | 2        | N/A         | N/A         | HINGE PLATE    |
| D2235-1 | 4        | N/A         | N/A         | RIB            |
| D2325   | 4        | N/A         | N/A         | SUPPORT GUSSET |
| D2327-3 | 2        | N/A         | N/A         | BUSHING        |
| D2581   | 2        | N/A         | N/A         | MTG BRKT       |
| D3442-1 | 2        | N/A         | N/A         | SHIM           |



D2221-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING  
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL  $\phi 0.257$  HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH  
D2989-041/-043 BASKET LID

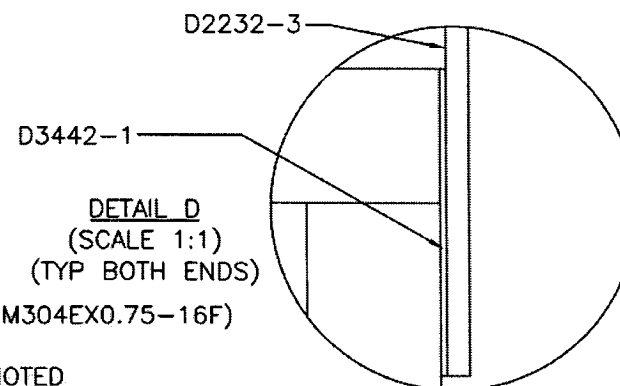
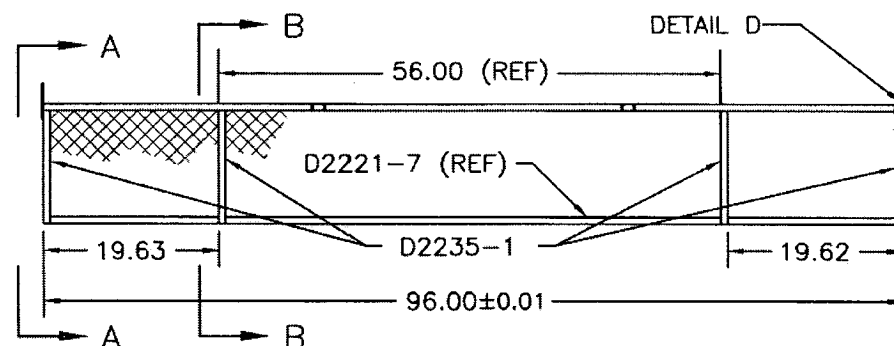
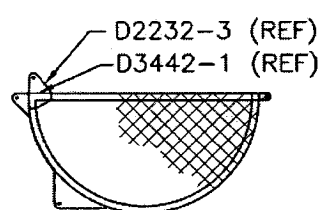
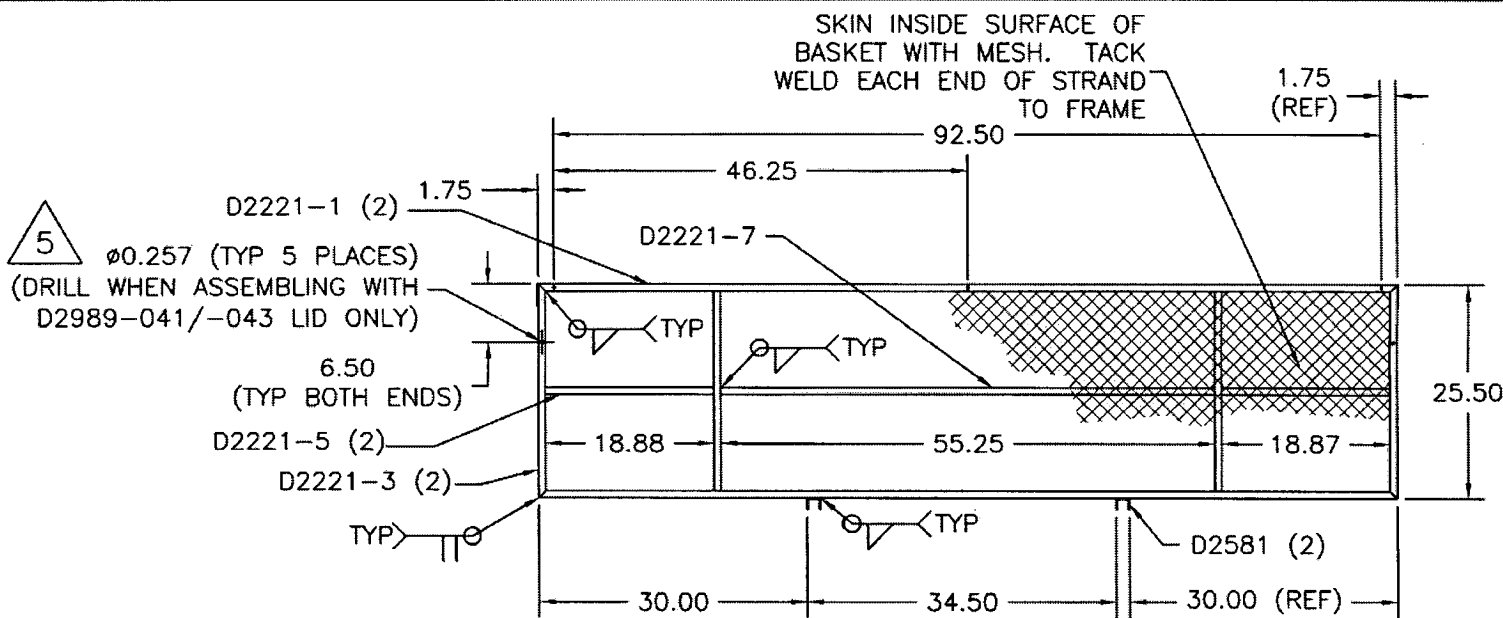
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| DESIGN  | BW       | DRAWN BY     | PH    | DART AEROSPACE LTD          |
|---------|----------|--------------|-------|-----------------------------|
| CHECKED |          | APPROVED     |       | HAMKESBURY, ONTARIO, CANADA |
| DATE    | 05.06.07 | TITLE        | D2221 | BASKET BASE ASSEMBLY (350)  |
|         |          | SCALE        | 1:20  |                             |
|         |          | SHEET 2 OF 3 |       |                             |
|         |          | REV. F       |       |                             |



# D2221 BASKET BASE ASSEMBLY

- MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- WELD PER DART QSI 004
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

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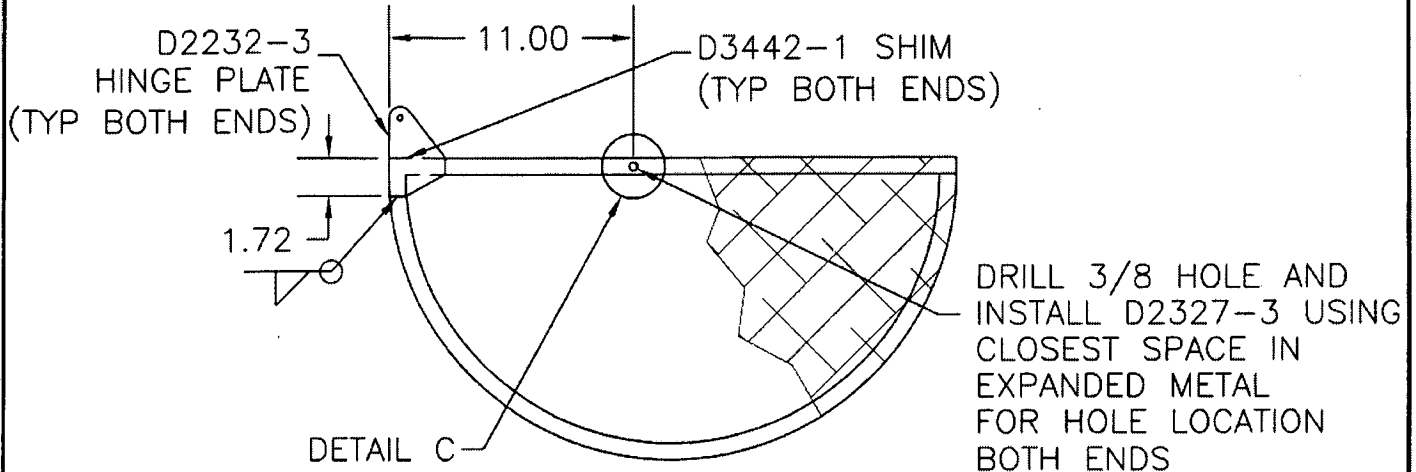
NO. 27817A  
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D2325 (REF)

RELEASED  
05.08.19

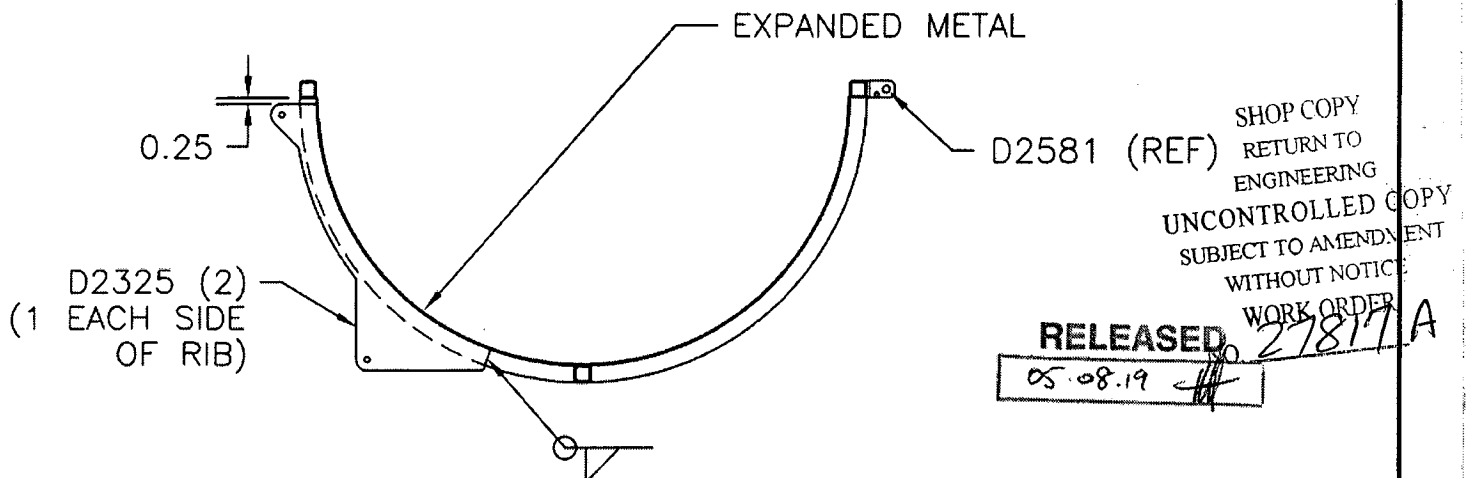
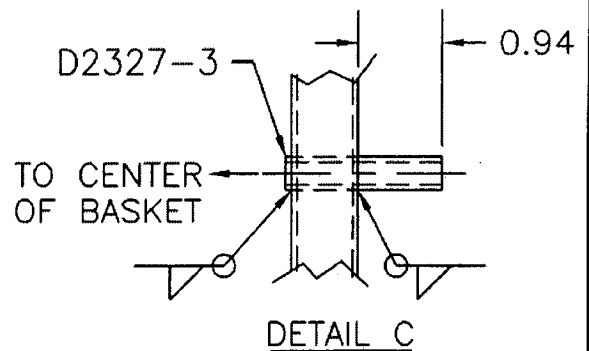


**DART**

|                        |                         |                                                   |                        |
|------------------------|-------------------------|---------------------------------------------------|------------------------|
| DESIGN<br>BW           | DRAWN BY<br>PH          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D2221                              | REV. F<br>SHEET 3 OF 3 |
| DATE<br>05.06.07       |                         | TITLE<br>BASKET BASE ASSEMBLY (350)               | SCALE<br>1:8           |



SECTION A-A SAME BOTH END RIBS



SECTION B-B SAME BOTH CENTER RIBS

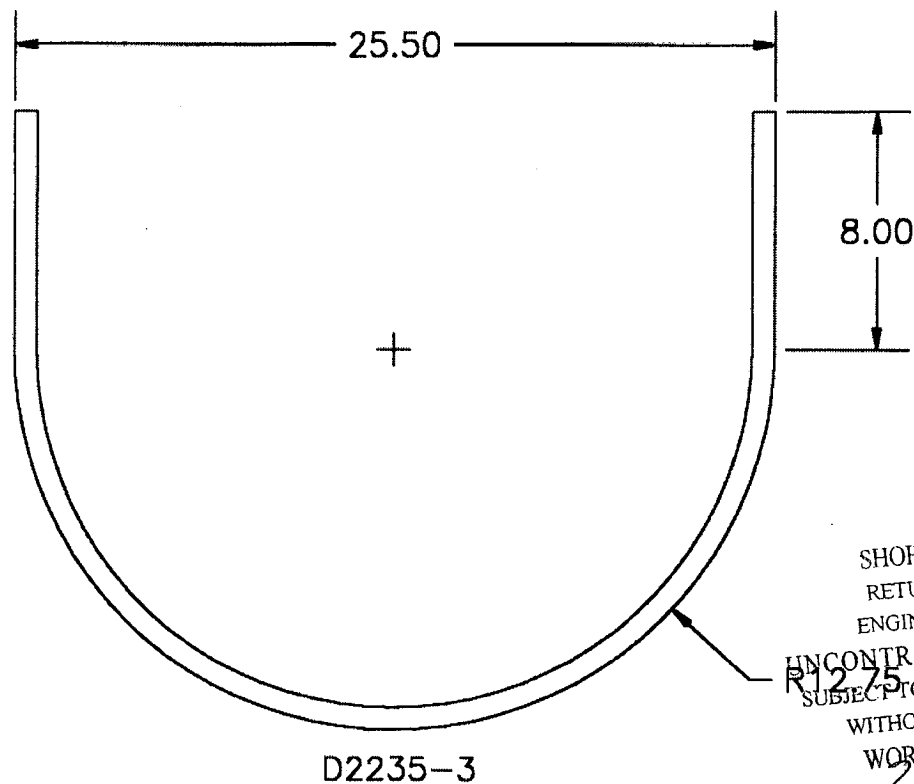
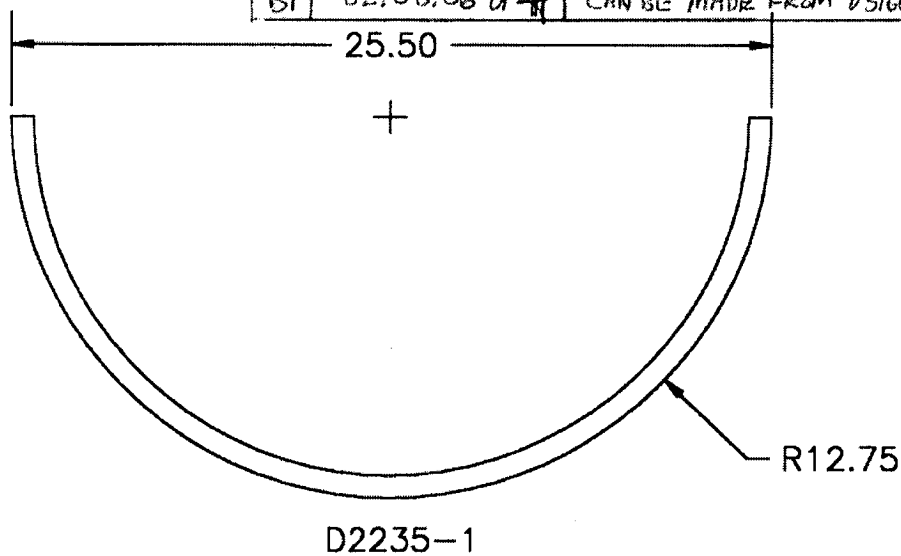
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|                      |                       |                                                              |              |
|----------------------|-----------------------|--------------------------------------------------------------|--------------|
| DESIGN               | DRAWN BY              | DART AEROSPACE LTD<br>VICTORIA INTERNATIONAL AIRPORT, CANADA |              |
| B WILLIAMS           | B WILLIAMS            | DRAWING NO.                                                  | REV. B       |
| CHECKED<br><i>BW</i> | APPROVED<br><i>BW</i> | D2235                                                        | SHEET 1 OF 1 |
| DATE                 | TITLE                 |                                                              | SCALE        |
| 94:12:16             | BASKET RIBS           |                                                              |              |
| BI                   | 02.08.06 <i>UP-#</i>  | CAN BE MADE FROM D3166-1                                     |              |

RELEASED  
R 960507



CAN BE MADE FROM D3166-1 *BI*  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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RETURN TO  
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